

Date: Monday, 06/04/2009 10:37:50 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPLATE
 Job Number : 46930
 Estimate Number : 13466
 P.O. Number :
 This Issue : 06/04/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D38053
 Drawing Number : D3805 REV.A
 Project Number : N/A
 First Issue : / / Type : SMALL /MED FAB Drawing Revision : A
 Previous Run : 46783 Material :
 Due Date : 06/04/2009 Qty: 1 Um: Each

Written By :
 Checked & Approved By :
 Comment : Est Rev:A 08-07-15 new issue DD verified by:EC
 Est Rev:B 08-07-29 new flat pattern DD verified by:EC
 Est Rev:C 09-03-04 rev.a as per dwg DD verified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S18GA 304/316 .050 Sheet



Comment: Qty.: 2.2909 sf(s)/Unit Total : 2.2909 sf(s)
 304/316 .050 Sheet
 batch: 108156 LB 9-4-6

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3805
 Dwg Rev: A LB 9-4-6
 Prog Rev: A

2-Deburr if necessary LB 9-4-6

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK



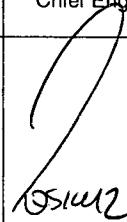
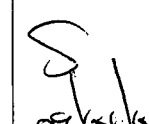


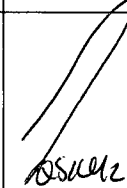

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
 Form as per Dwg D3805 using Jigs DT8261 and DT8326

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3805-3 PAR #: N/A Fault Category: Prod / IPB ASS, mod # Small NCR: Yes No DQA: D Date: 09/04/09
E.3805-043 / D306-640-251/249
 Resolution: _____ Disposition: _____ QA: N/C Closed: D Date: 09/04/09

NCR: 46930		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/4/06	# 2.0	one part has a flat out around one hole (Detail 5) R.C. sheet was Too short in that area.		scrap: replace qty 1 extras made - use for drug revision sample.	IB 9-4-06			
09/01/07	5.0	part was bend @ the wrong end (curved @ the rht location) R.C. Lack of attention to check		- Try to re-work the curve back to flat: bend the Prod as per drawing. - Ensure to look at drugs prior to performing task	SA 09/01/07			

NOTE: Date & initial all entries

Date: Monday, 06/04/2009 10:37:50 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 46930

Part Number: D38053

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

[Handwritten signatures and dates: 06-04-07, 06-04-06]

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W/D 046621

EL 9-4-7

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/08 *[Signature]*

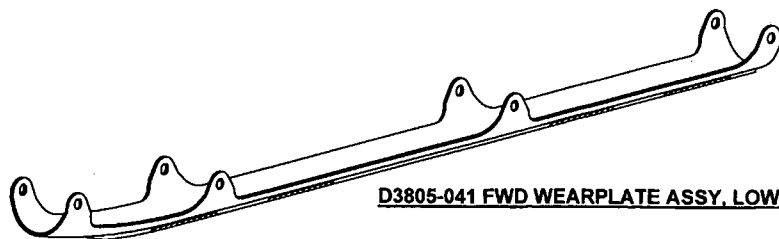
Job Completion



9 08-04-07

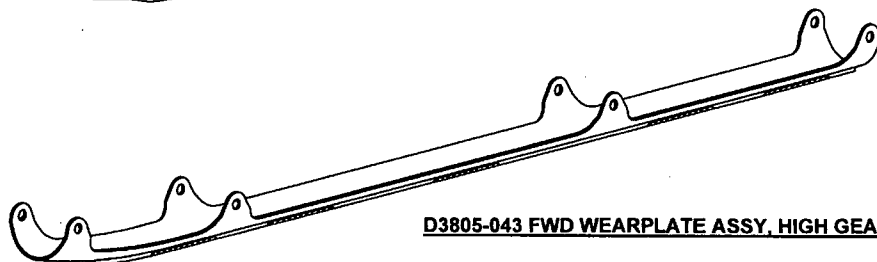
8 7 6 5 4

D



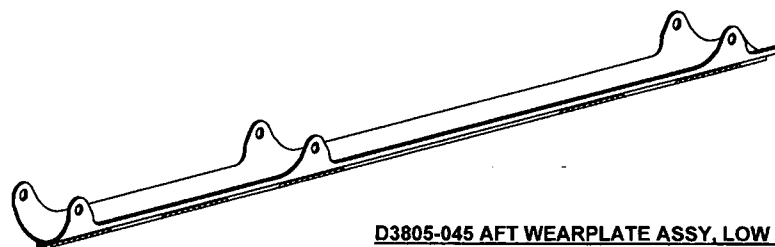
D3805-041 FWD WEARPLATE ASSY, LOW GEAR

C



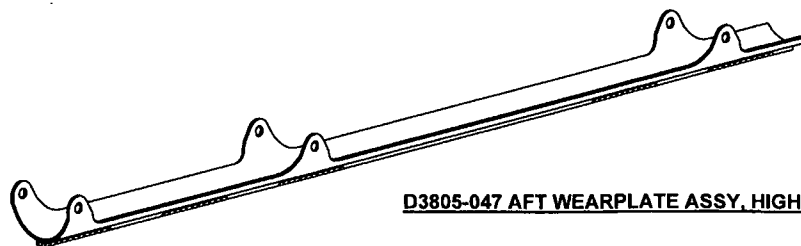
D3805-043 FWD WEARPLATE ASSY, HIGH GEAR

B



D3805-045 AFT WEARPLATE ASSY, LOW GEAR

A



D3805-047 AFT WEARPLATE ASSY, HIGH GEAR

8 7 6 5 4

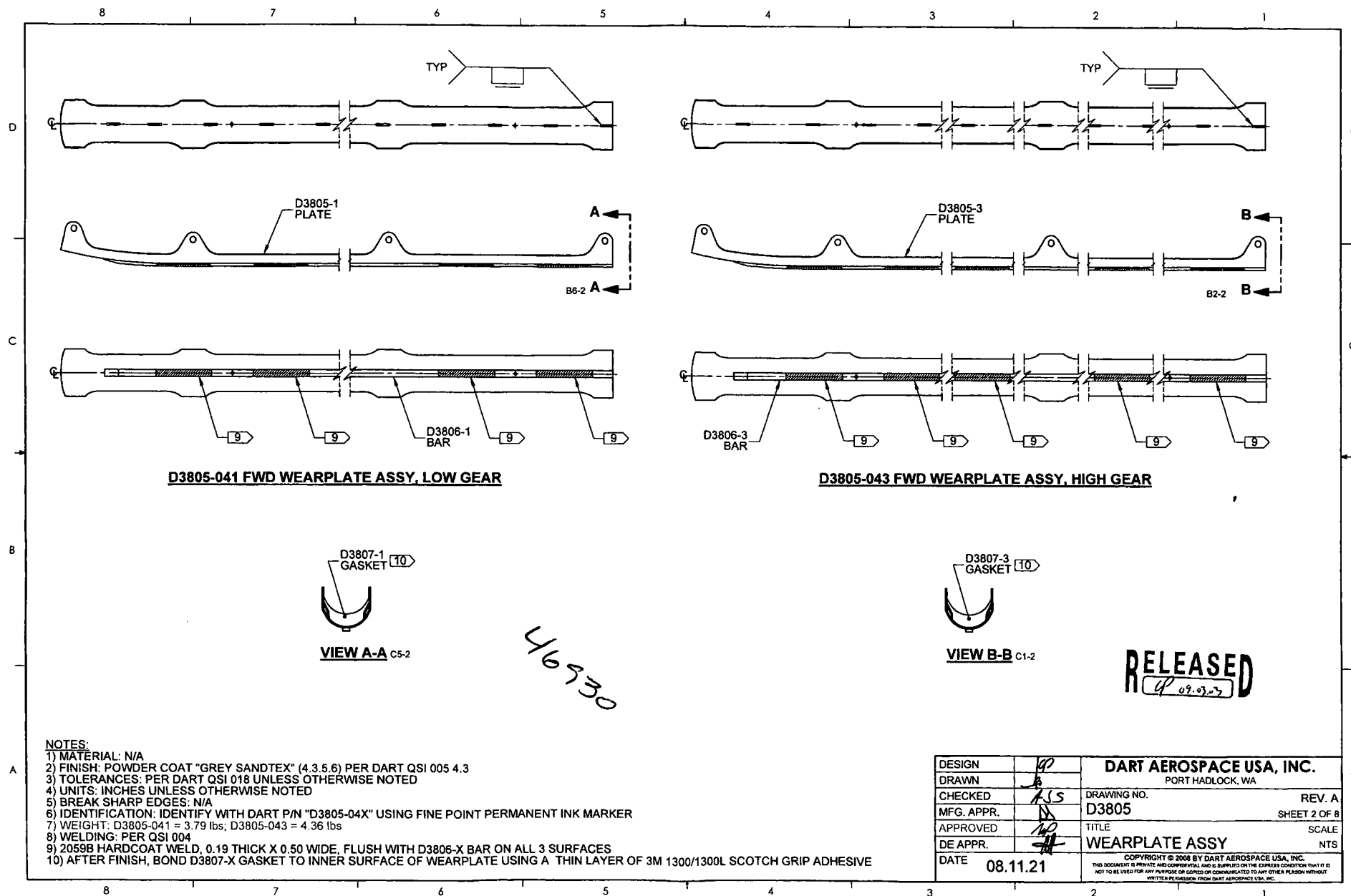
3 2 1

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
19	1				D3807-1	GASKET
20		1			D3807-3	GASKET
21			1		D3807-5	GASKET
22				1	D3807-7	GASKET
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

RELEASED
47 09.03.03
PL ECN 09-538

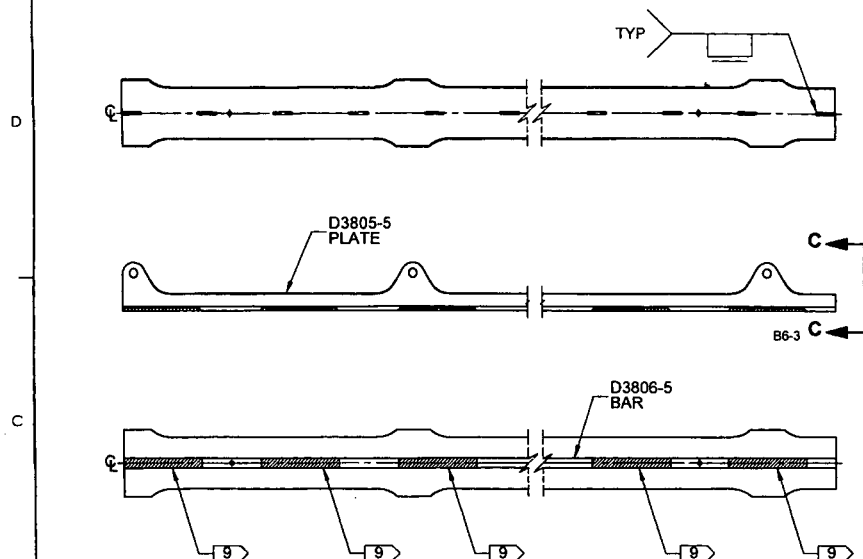
A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3805	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	08.11.21	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC.</small> <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

Handwritten signature/initials

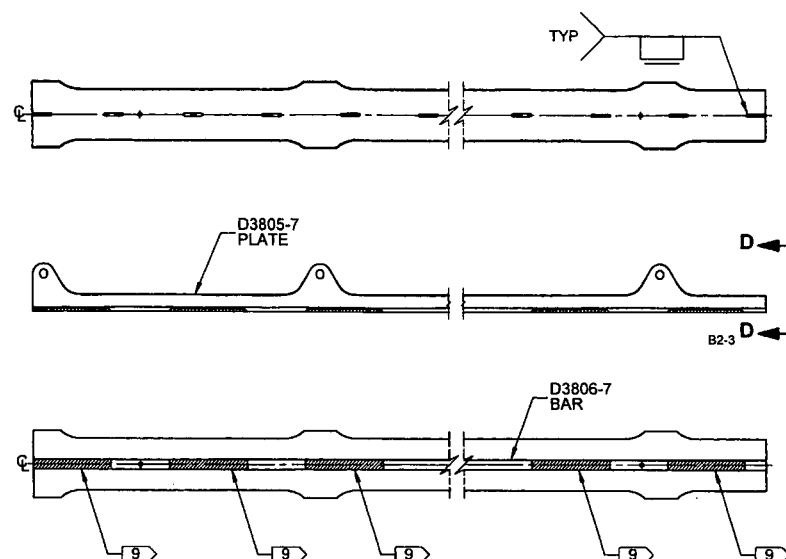


DESIGN	10	DART AEROSPACE USA, INC.	
DRAWN	10	PORT HADLOCK, WA	
CHECKED	10	DRAWING NO.	REV. A
MFG. APPR.	10	D3805	SHEET 2 OF 8
APPROVED	10	TITLE	SCALE
DE APPR.	10	WEARPLATE ASSY	NTS
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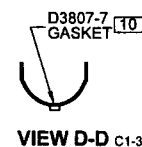
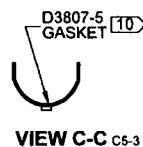
8 7 6 5 4 3 2 1



D3805-045 AFT WEARPLATE ASSY.



D3805-047 AFT WEARPLATE ASSY.



RELEASED
09.03.07

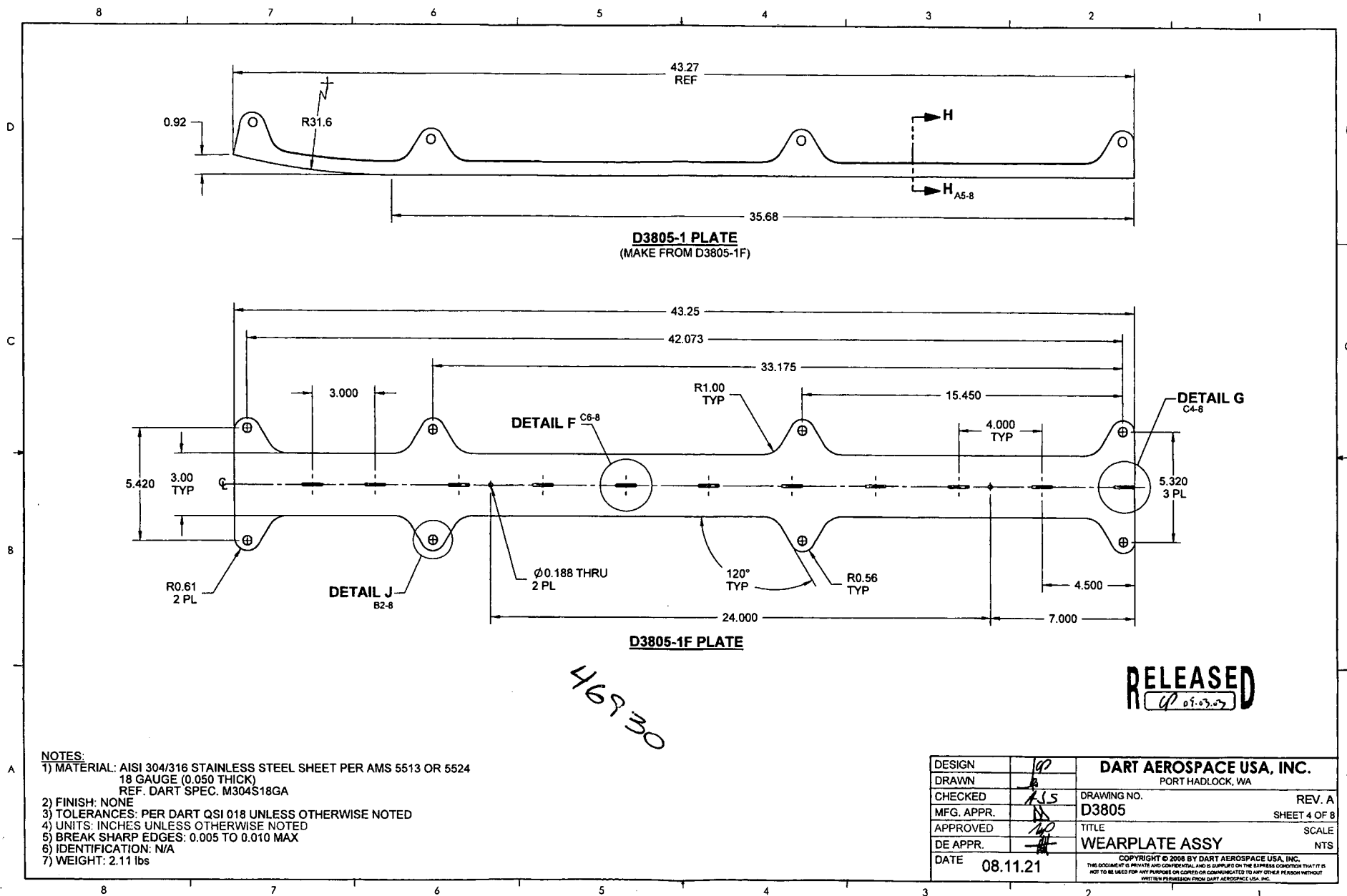
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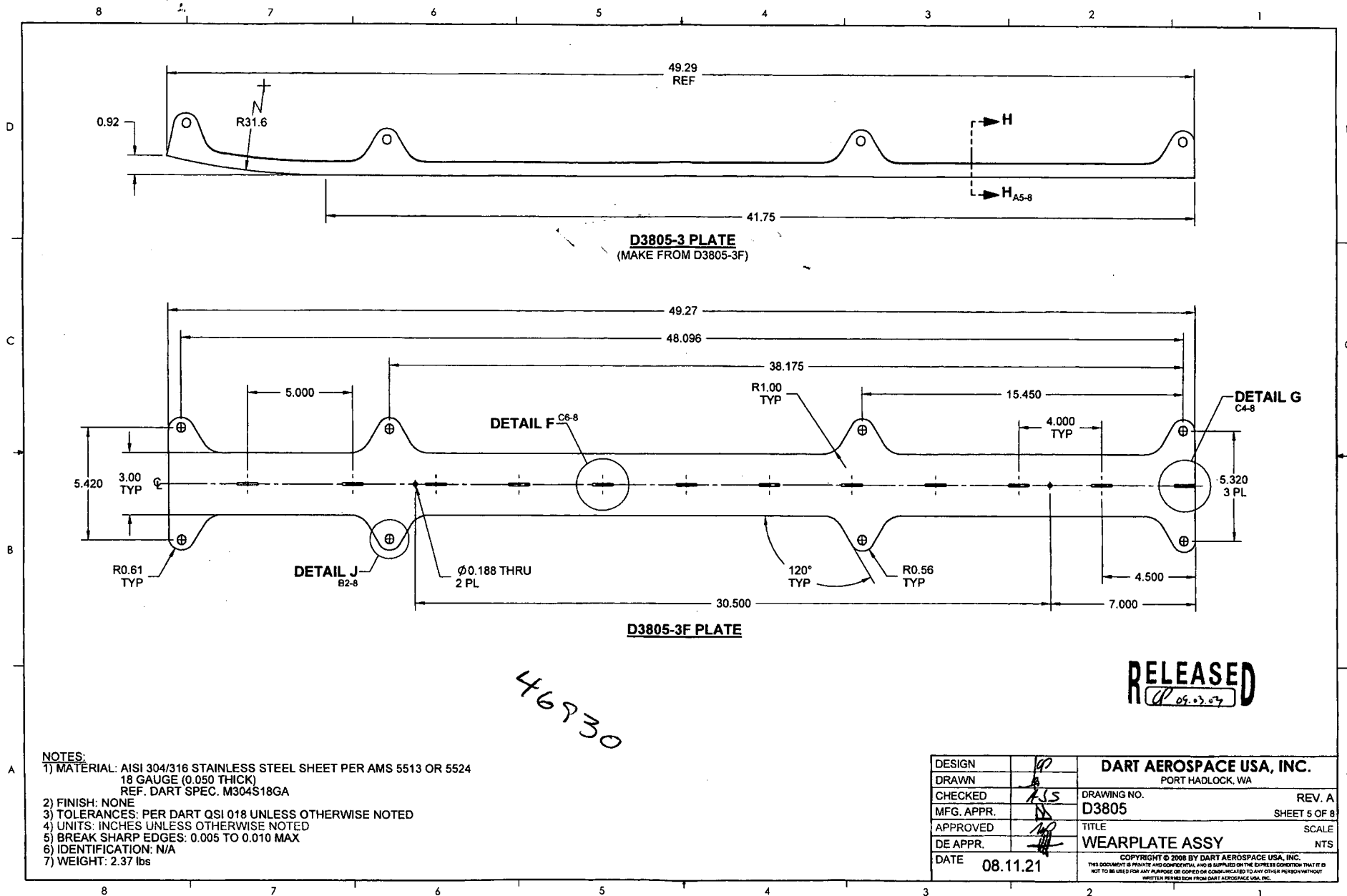
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3805-045 = 3.93 lbs; D3805-047 = 4.21 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

DESIGN	149	DART AEROSPACE USA, INC.	
DRAWN	149	PORT HADLOCK, WA	
CHECKED	149	DRAWING NO.	REV. A
MFG. APPR.	149	D3805	SHEET 3 OF 8
APPROVED	149	TITLE	SCALE
DE APPR.	149	WEARPLATE ASSY	NTS
DATE	08.11.21	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

46930

8 7 6 5 4 3 2 1

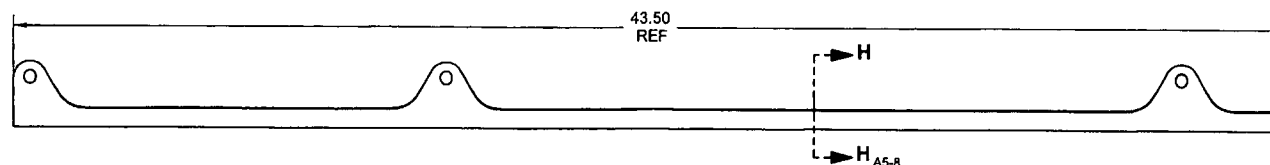




8 7 6 5 4 3 2 1

D

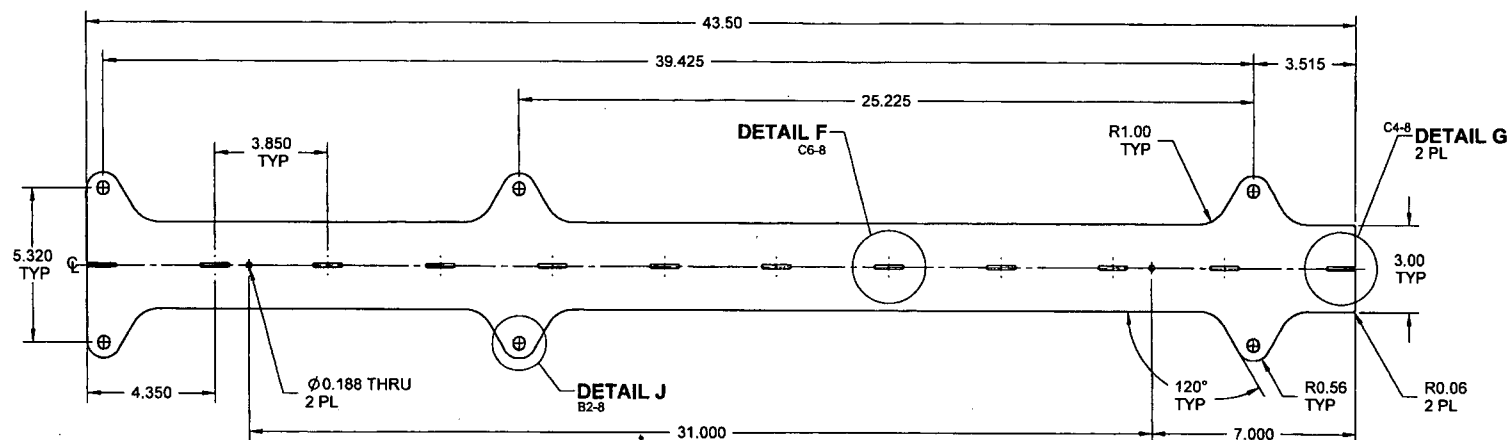
D



D3805-5 PLATE
(MAKE FROM D3805-5F)

C

C



D3805-5F PLATE

RELEASED
46930

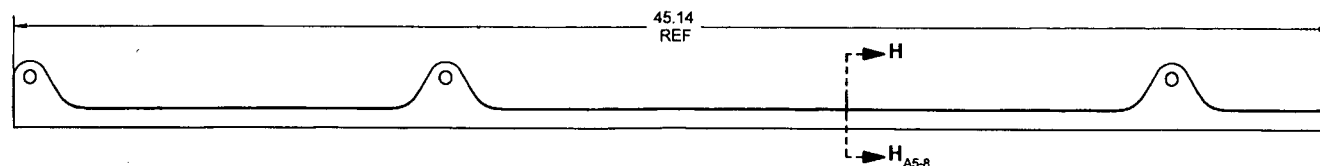
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.06 lbs

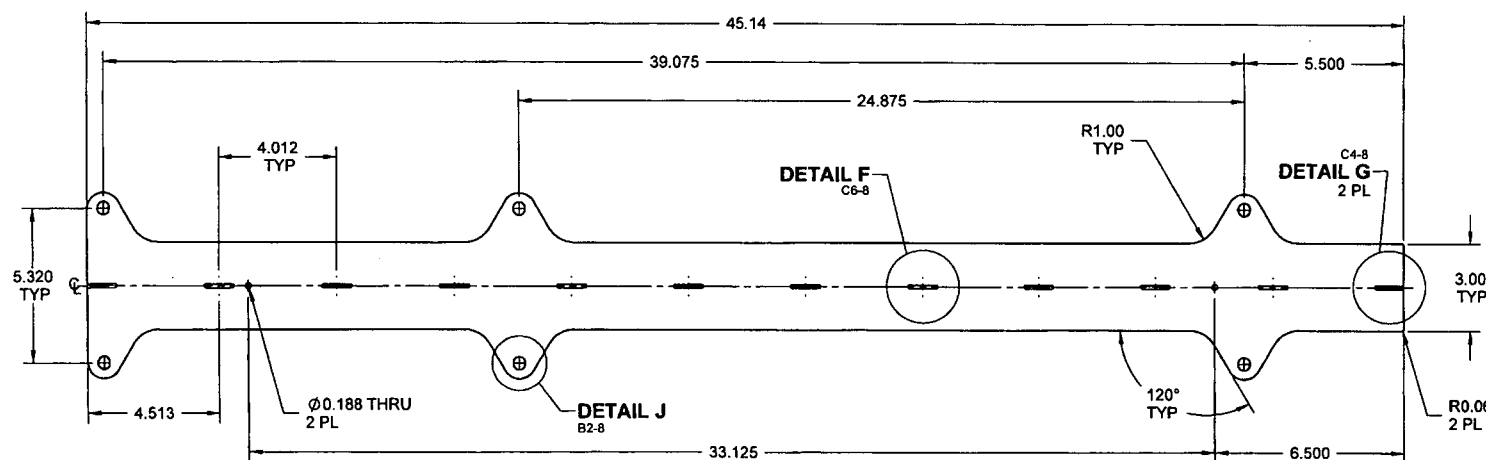
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CHECKED	AS	DRAWING NO.	REV. A
MFG. APPR.	AS	D3805	SHEET 6 OF 8
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	WEARPLATE ASSY	NTS
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



D3805-7 PLATE
(MAKE FROM D3805-7F)



D3805-7F PLATE

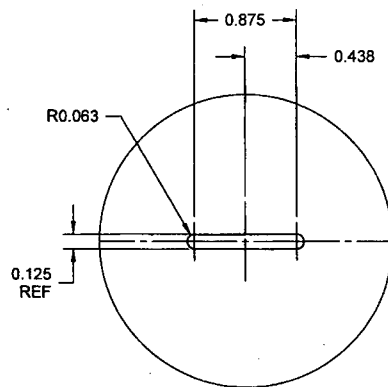
RELEASED
09.03.07

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.13 lbs

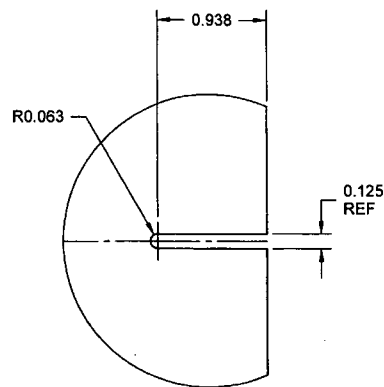
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DRAWN	46930	PORT HADLOCK, WA	
CHECKED	46930	DRAWING NO.	REV. A
MFG. APPR.	46930	D3805	SHEET 7 OF 8
APPROVED	46930	TITLE	SCALE
DE APPR.	46930	WEARPLATE ASSY	NTS
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8 7 6 5 4 3 2 1



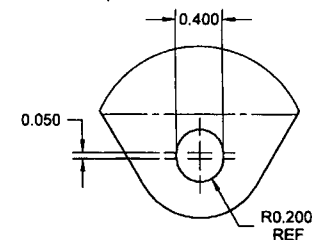
DETAIL F
SLOT DETAIL TYP
SCALE 4X

C5-4
C5-5
C4-6
C4-7



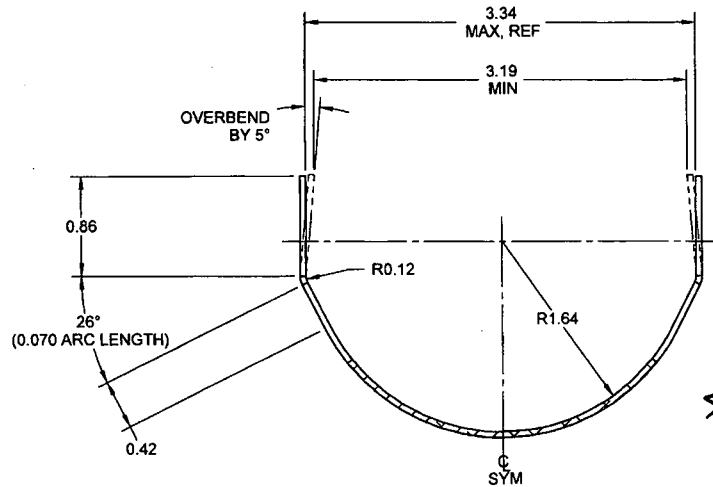
DETAIL G
SLOT DETAIL TYP
SCALE 4X

C1-4
C1-5
C1-6
C2-7



DETAIL J
SCALE 4X

B6-4
B7-5
B5-6
B5-7



SECTION H-H
SCALE 4X

D3-4
D3-5
D3-6
D3-7

46930

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4709.03.03

DESIGN	19	DART AEROSPACE USA, INC.	
DRAWN	19	PORT HADLOCK, WA	
CHECKED	215	DRAWING NO.	REV. A
MFG. APPR.	19	D3805	SHEET 8 OF 8
APPROVED	19	TITLE	SCALE
DE APPR.	19	WEARPLATE ASSY	NTS
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